












split

Date: Wednesday, 25/07/2007 8:32:28 AM  
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ARM
Job Number : 33729	
Estimate Number : 11047	
P.O. Number : N/A	Part Number : D28441
This Issue : 25/07/2007 S.O. No. : N/A	Drawing Number : D2844 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A	Drawing Revision : A
Previous Run : 32284	Material : N/A
Written By : <u>W</u>	Due Date : 24/08/2007
Checked & Approved By : <u>W</u>	Qty: 12 Um: Each
Comment : Est: B 00.11.01 Removed P/O for Powder Coat - in house processEC	
Additional Product	
Job Number: 	
Seq. #:	Machine Or Operation: Description :
1.0	M304TRO500W035 304 RD Tube .500 x .035W
 	
Comment: Qty.: 1.9941 f(s)/Unit Total: 23.9287 f(s) 304 RD Tube .500 x .035W M304TRO500W035 Punch 304/316 Seamless tubing with 2B finish, 1/2" OD x .035 Wall 21.49" long (Hole ctr. to hole ctr.) using Jig DT 8012 <u>M104862</u> <u>10</u> Batch <u>M104565</u> <u>3</u> <u>07-07-24</u>	
2.0	BRAKE NC NC BRAKE
 	
Comment: BAND SAW Form per Dwg D2844 using brake and bending Jig DT 8238-B Deburr <u>FF</u> <u>07-07-26</u> <u>07-07-24</u>	
3.0	QC5 INSPECT WORK TO CURRENT STEP
 	
Comment: INSPECT WORK TO CURRENT STEP <u>En</u> <u>07/07/26</u> <u>3</u>	
4.0	POWDER COATING POWDER COATING
 	
Comment: POWDER COATING Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3 <u>BR</u> <u>07-07-26</u> <u>3</u>	
5.0	QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION
 	
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION <u>En</u> <u>07/07/26</u> <u>43</u>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2844-1 PAR #: N/A Fault Category: Prod / Fms. ass <sup>med & small</sup> NCR: Yes No DQA: D Date: 07/07/27  
 QA: N/C Closed: 18 Date: 07.07.27

NCR: <u>33729</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>07/07/25</u>	<u>3.0</u>	<u>3 x D2844-1's were made using 0.049" wall thickness of 0.035" wall.</u> <u>RC Employee pulled wrong part.</u>	<u>[Signature]</u>	<u>split w/o and continue but do not pass step 6.0 (QC #6)</u> <u>Parts are good. per QCR</u>	<u>[Signature]</u> <u>07.07.26</u>	<u>[Signature]</u> <u>07/07/26</u>	<u>[Signature]</u> <u>07/07/26</u>	<u>[Signature]</u> <u>07/07/26</u>

NOTE: Date & initial all entries



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Drawing Name: ARM

Job Number: 33729

Part Number: D28441

Job Number:



Seq. #: Machine Or Operation: Description :

6.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK  
ensure parts are still as per dwg D2844

*En 07/07/26 (03)*

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: \_\_\_\_\_

*7/7/26 (3X) SQ*

8.0

QC21

FINAL INSPECTION/W/O RELEASE



*(3)*

Comment: FINAL INSPECTION/W/O RELEASE

*Done 07/07/27*

Job Completion



POSITIVE RECALL

EFFECTIVE *07/07/26* AUTH *h*

RELEASED *h* DATE *07/07/26*

*h 07/07/27*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

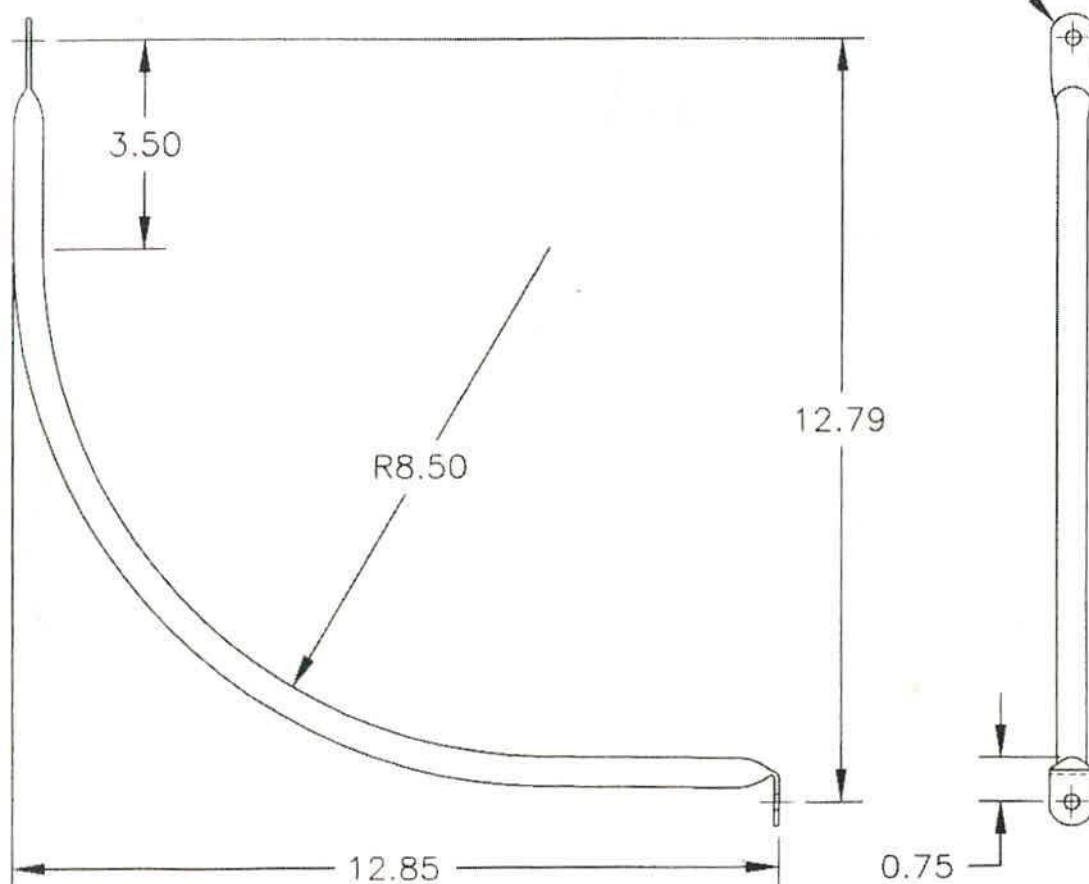
NOTE: Date & initial all entries



DESIGN <i>KE</i>	DRAWN BY <i>KE</i>	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED <i>PAH</i>	APPROVED <i>CS</i>	DRAWING NO. D2844	REV. A SHEET 1 OF 2
DATE 98.10.14		TITLE ARM	SCALE 1:3
A	98.10.14	NEW ISSUE	

RELEASED  
98.11.11 KE

PUNCH ENDS PER SPEC CONTROL DRAWING D2727



D2844-1

MATERIAL: AISI 304/316 SS TUBE,  $\phi 0.50 \times 0.035$  WALL "

ENSURE TUBE IS SEAMLESS

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

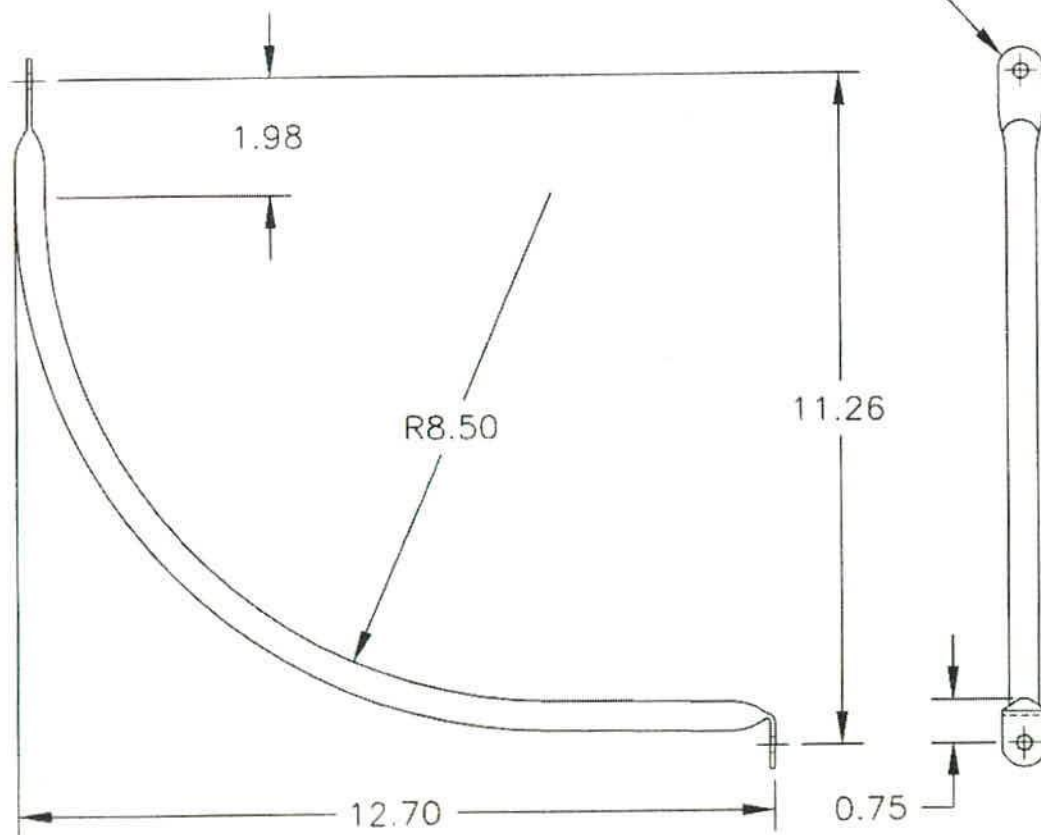




DESIGN KE	DRAWN BY KE	DART AEROSPACE USA, INC. FAIRCHILD INTERNATIONAL AIRPORT, WA	
CHECKED DHA	APPROVED [Signature]	DRAWING NO. D2844	REV. A SHEET 2 OF 2
DATE 98.10.14	TITLE ARM		SCALE 1:3

RELEASED  
19.11.11 KE

PUNCH ENDS PER SPEC CONTROL DRAWING D2727



D2844-3

MATERIAL: AISI 304/316 SS TUBE,  $\phi 0.50 \times 0.035$  WALL  
ENSURE TUBE IS SEAMLESS

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries